

Date: Wednesday, 1/23/2008 12:05:51 PM  
 User: Kim Johnston

## Process Sheet

|                       |                                     |          |                  |                   |     |      |
|-----------------------|-------------------------------------|----------|------------------|-------------------|-----|------|
| Customer              | CU-DAR001 Dart Helicopters Services |          | Drawing Name     | MIRROR BRACKET RH |     |      |
| Job Number            | 36938                               |          |                  |                   |     |      |
| Estimate Number       | 10147                               |          |                  |                   |     |      |
| P.O. Number           |                                     |          | Part Number      | D20132            |     |      |
| This Issue            | 1/23/2008                           | S.O. No. | Drawing Number   | D2013 REV C       |     |      |
| Prsht Rev.            | NC                                  |          | Project Number   | N/A               |     |      |
| First Issue           | / /                                 | Type     | Drawing Revision | C                 |     |      |
| Previous Run          | 36467A02                            |          | Material         |                   |     |      |
| Written By            |                                     |          | Due Date         | 1/30/2008         |     |      |
| Checked & Approved By | <u>PS</u> 080123                    |          | Qty:             | 5                 | Um: | Each |
| Comment               | Est Rev.A New Issue 05-11-01 JLM    |          |                  |                   |     |      |

## Additional Product

Job Number:



| Seq. #:   | Machine Or Operation: | Description :                |
|---|-----------------------|------------------------------|
| 1.0   | M304TR0750W049        | 304 RD Tube .750 x .049W     |
|   |                       |                              |
| Comment: Qty.: 2.0447 f(s)/Unit Total : 10.2233 f(s)<br>Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing<br>(M304TR0.750W.049)<br>Batch: <u>M 107 098</u>  |                       |                              |
| 2.0   | BRAKE NC              | NC BRAKE                     |
|   |                       |                              |
| Comment: NC BRAKE<br><br>1-Punch as per template D2013-T1and Dwg D2013<br><br>2-Flatten ends of D2013-2 tube as per Dwg D2013 using DT8545<br><br>3-Bend (1) tube as per Dwg D2013 using Jig DT8201identify as D2013-2.<br><br>4-Deburr as required |                       |                              |
| 3.0   | QC5                   | INSPECT WORK TO CURRENT STEP |
|   |                       |                              |
| Comment: INSPECT WORK TO CURRENT STEP   |                       |                              |

|                                       |      |                              |
|---------------------------------------|------|------------------------------|
| 4.0                                   | QC21 | FINAL INSPECTION/W/O RELEASE |
|                                       |      |                              |
| Comment: FINAL INSPECTION/W/O RELEASE |      |                              |

|                |  |                   |
|----------------|--|-------------------|
| Job Completion |  | <u>2008/01/20</u> |
|                |  | (5)               |
|                |  | U (5)             |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/01/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**RELEASED**

KE 94.06.10

**DART**

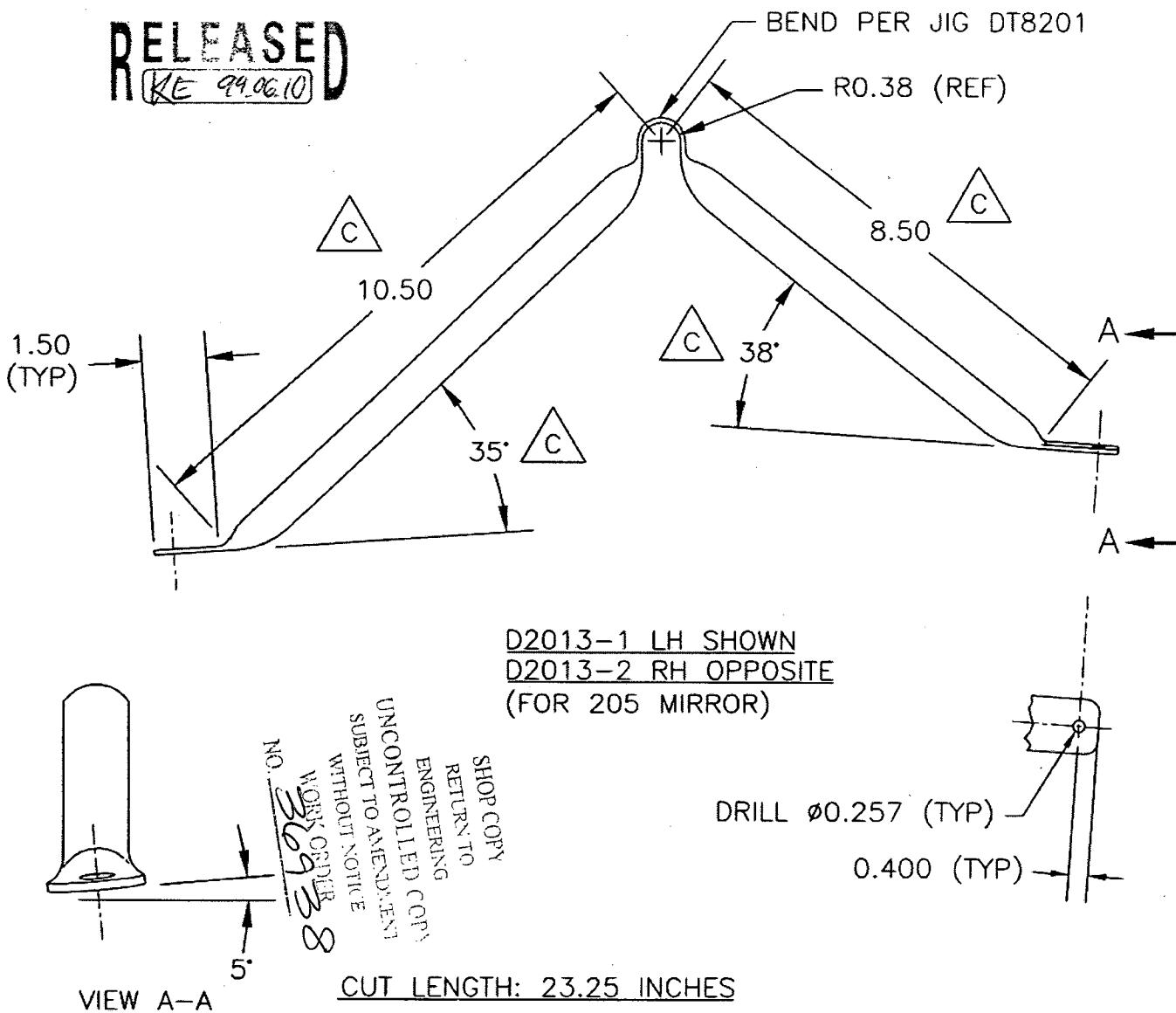


DESIGN DRAWN BY DART AEROSPACE LTD  
JB. RF HAWKESBURY, ONTARIO, CANADA  
CHECKED APPROVED DRAWING NO. REV. C  
DATE 99.06.07 D2013 SHEET 1 OF 3

A 90.10.22 NEW ISSUE

B 94.06.15 REDRAWN

C 99.06.07 REDRAWN, CHANGE OF DIMENSIONS

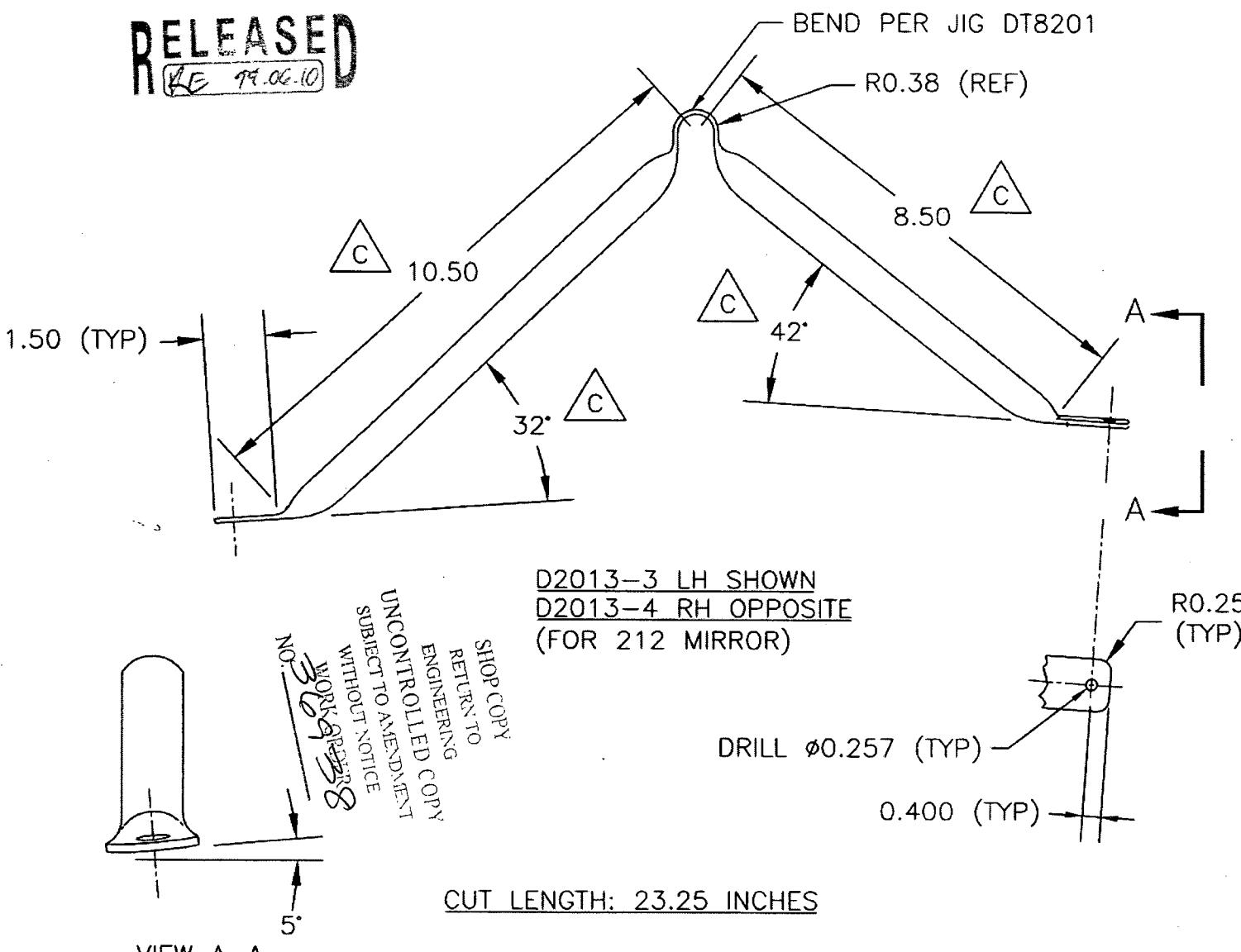


**RELEASED**  
RE 99.06.10

**DART**

© DART  
1999

|                  |                                |   |
|------------------|--------------------------------|---|
| DESIGN<br>JB     | DRAWN BY<br>RF                 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br>KE    | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2013                              |
| DATE<br>99.06.07 | TITLE<br>MIRROR BRACKET        | REV. C<br>SHEET 2 OF 3<br>SCALE<br>NTS            |



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[RE 99.06.10]

RE 99.06.10



QA COPY 155  
CENTRAL

|         |                |                             |              |
|---------|----------------|-----------------------------|--------------|
|         |                | DRAWN BY<br><i>RJ</i>       |              |
|         |                | HAWKESBURY, ONTARIO, CANADA |              |
|         |                | DART AEROSPACE LTD          |              |
| DESIGN  | JB             |                             |              |
| CHECKED | <i>KE</i>      | APPROVED                    | DRAWING NO.  |
| DATE    | 99.06.07       | TITLE                       | SHEET 3 OF 3 |
|         | MIRROR BRACKET | SCALE                       | REV. C       |
|         |                | NTS                         |              |

The technical drawing illustrates a mechanical component with two parallel legs. The left leg has a vertical height of 1.50 (TYP) and a bend radius of R0.38 (REF). The right leg has a bend radius of 8.75 and a vertical height of 1.50 (TYP). Both legs feature a 35° angle relative to the horizontal. The top of the component is labeled "BEND PER JIG DT8201". Reference callouts "A" point to the top edge of the legs.

POSITION TUBE  
OFFSET JIG  
NO. 5  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER 36938  
CUT LENGTH  
ENGINEERING CONTROLLED COPY  
RETURN TO  
SHOP COPY

95°

36938

D2013-5 LH SHOWN  
D2013-6 RH OPPOSITE  
(FOR 204 MIRROR)

A technical drawing showing a slot with a central circular feature. A dimension line indicates a width of 0.400 (TYP).

VIEW A-A

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 O.D. x 0.049 WALL